

Date: Wednesday, 28/01/2009 4:59:35 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CONSOLE ASSEMBLY
Job Number : 45314	
Estimate Number : 11224	
P.O. Number :	Part Number : D206547043 <i>BK</i>
This Issue : 28/01/2009 S.O. No. :	Drawing Number : D206-547 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : F
Previous Run : 44316	Material :
Written By :	Due Date : 20/02/2009 Qty: 3 Um: Each
Checked & Approved By : <i>JUL 09.01.29</i>	
Comment : Est Rev: 06-01-05 Removed Packing Kit JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2024	Console Extrusion
-----	-------	-------------------



Comment: Qty.: 3.5910 Each(s)/Unit Total : ~~14.3640~~ Each(s)
 D2024 Extrusion *10.773*
 Batch *M1*

FF 09-05-05

③

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates DT
 8264-1, DT 8264-2, DT8264-3, DT8264-4

2-Deburr

FF 09-05-06

③

3.0	D26021	Console Side, 206 Console
-----	--------	---------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~4.0000~~ Each(s)
 Pick: *3*
 Qty Part Number Description Batch
 1 D2602-1 Side LH *B46248*

FF 09-05-05

③

4.0	D26022	Console Side, 206 Console
-----	--------	---------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : ~~4.0000~~ Each(s)
 Pick: *3*
 Qty Part Number Description Batch
 1 D2602-2 Side RH *B46249*

FF 09-05-05

③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 28/01/2009 4:59:36 PM
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Process Sheet

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Drawing Name: CONSOLE ASSEMBLY

Job Number: 45314

Part Number: D206547043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2606

Console Bracket, 206/407 Console



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2606

Bracket

B38590

FF 09-05-05

(3)

6.0

D2607

Bracket, 206 Console



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2607

Bracket

B32820

FF 09-05-05

(3)

7.0

MS20470AD33

Rivet, Universal Head



Comment: Qty.: 8.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 MS20470AD3-3

Rivet

M16941

FF 09-05-05

(3)

8.0

MS20470AD34

Rivet, Universal Head



Comment: Qty.: 20.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

20 MS20470AD3-4

Rivet

M15541

FF 09-05-05

(3)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Grind weld relief chamfer as per Dwg D206-547


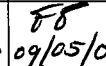


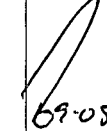
2-Rivet extrusion to sides as per Dwg D206-547 using Rivet MS20470AD3-4

FF 09-05-06

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-547-043 PAR #: N/A Fault Category: Prod/Engassy med & small NCR: Yes No DQA: R Date: 09/05/07
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: _____ Date: _____

NCR: <u>45314</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		The 2710-1 & -2 faults do not have the angle cut out on the top section per the template. This will cause an interference during assembly. Part were already transfer drilled & riveted. R.C. Human error / LAC LAC.		Identify each part as to which assembly they are off of due to transfer drilling. Ensure to not enlarge the rivet holes. Trim angle per template & re-rivet.	 09/05/07	 09/05/07		 09-05-07
				Rivets did not have to be removed.				

NOTE: Date & initial all entries

Date: Wednesday, 28/01/2009 4:59:36 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY

Job Number: 45314

Part Number: D206547043

Job Number:



Seq. #: Machine Or Operation: Description :

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/08
(X3RH)
(X3LH)

11.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Tack weld as per Dwg D206-547

A/R AL ROD Batch: M106330

(3X4)
(3XRH)
M-H 09/05/12
D 09-05-12

12.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/13
(X3RH)
(X3LH)

13.0 QC10 VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/05/13
(X3RH)
(X3LH)

14.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Rivet sides and brackets per Dwg D206-547 using Rivet MS20470AD3-3

FF 09-05-13 (3)

15.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/14 (X3)

16.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:50
320°
10:00

umd

09/05/14

(X3)

17.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/05/14 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 28/01/2009 4:59:36 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY

Job Number: 45314

Part Number: D206547043

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP45241

8/09/05/14 x3

19.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/19

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

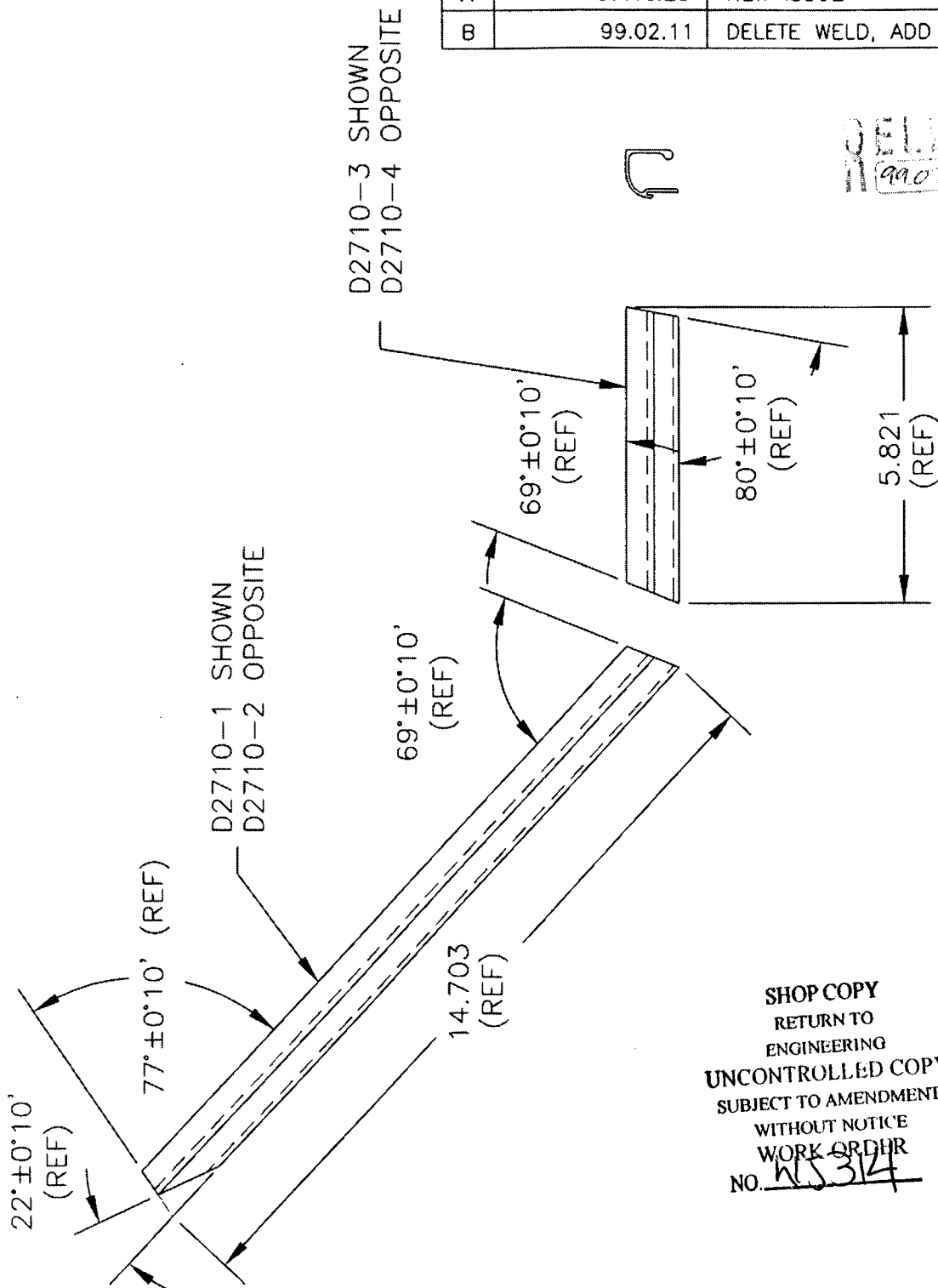
NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JP	APPROVED KE	DRAWING NO. D2710	REV. B SHEET 1 OF 1
DATE 99.02.11		TITLE CONSOLE SIDE RAIL	SCALE 1:3
A	97.10.25	NEW ISSUE	
B	99.02.11	DELETE WELD, ADD TEMPL. (TSR A1020)	



RELEASED
99.03.03 KE



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WORK ORDER
NO. W5314

MATERIAL: MAKE FROM D2024 EXTRUSION
MAKE PER TEMPLATE # DT8264
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED KE	DRAWING NO. D206-547	REV. F SHEET 1 OF 5
DATE 99.02.11		TITLE CONSOLE ASSEMBLY	SCALE NTS
-	82.11.23	NEW ISSUE	
A	83.01.18	REDRAWN, ADD NOTE 4	
B	84.10.23	D206-547 WAS 01.B.81.017	
C	89.03.30	REDRAWN	
D	90.12.06	COMPANY NAME CHANGE MS20470 WAS MS20426 DIM 1.312 WAS 1.0, 13.160 WAS 12.85	
E	97.10.22	REDRAWN, ADD -043, -045, -047	
F	99.02.11	ADD MS20470AD3-3 RIVET (NC 143) UPDATED WELD DETAIL	

RELEASED
99.03.05 RE

-041	-043	-045	-047	PART NUMBER	DESCRIPTION
X				D206-547-041	CONSOLE ASSEMBLY
	X			D206-547-043	CONSOLE ASSEMBLY
		X		D407-547-045	CONSOLE ASSEMBLY
			X	D407-547-047	CONSOLE ASSEMBLY
1				D2601-1	CONSOLE SIDE
1				D2601-2	CONSOLE SIDE
	1			D2602-1	CONSOLE SIDE
	1			D2602-2	CONSOLE SIDE
		1		D2603-1	CONSOLE SIDE
		1		D2603-2	CONSOLE SIDE
			1	D2604-1	CONSOLE SIDE
			1	D2604-2	CONSOLE SIDE
1		1		D2605	CONSOLE BRACKET
	1		1	D2606	CONSOLE BRACKET
1	1			D2607	CONSOLE BRACKET
		1	1	D2608	CONSOLE BRACKET
1		1		D2709-1	CONSOLE SIDE RAIL
1		1		D2709-2	CONSOLE SIDE RAIL
1		1		D2709-3	CONSOLE SIDE RAIL
1		1		D2709-4	CONSOLE SIDE RAIL
	1		1	D2710-1	CONSOLE SIDE RAIL
	1		1	D2710-2	CONSOLE SIDE RAIL
	1		1	D2710-3	CONSOLE SIDE RAIL
	1		1	D2710-4	CONSOLE SIDE RAIL
10	8	8	6	MS20470AD3-3	RIVET
18	20	18	20	MS20470AD3-4	RIVET

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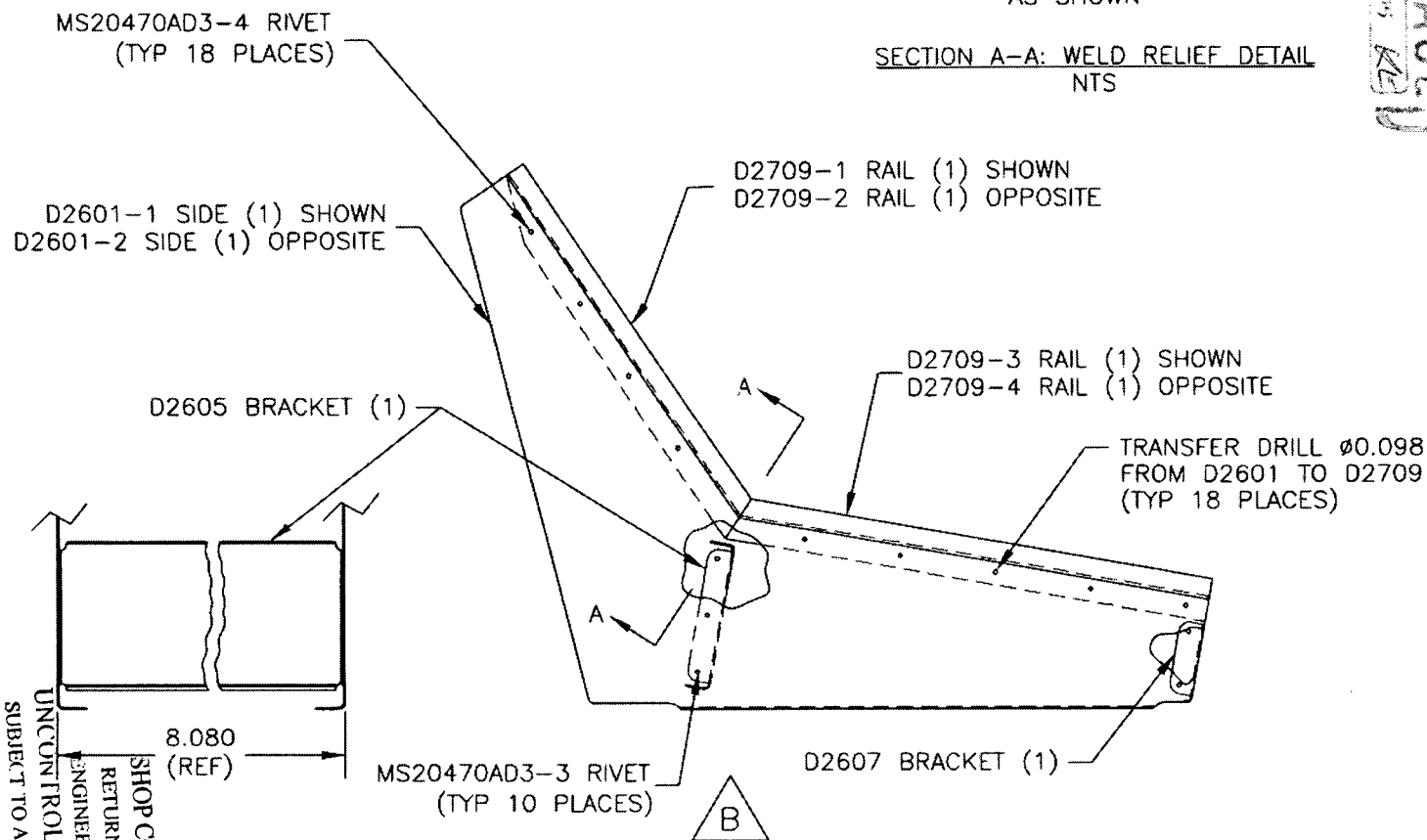
DART

RELEASED
990305 KE



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D206-547-041 (206 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

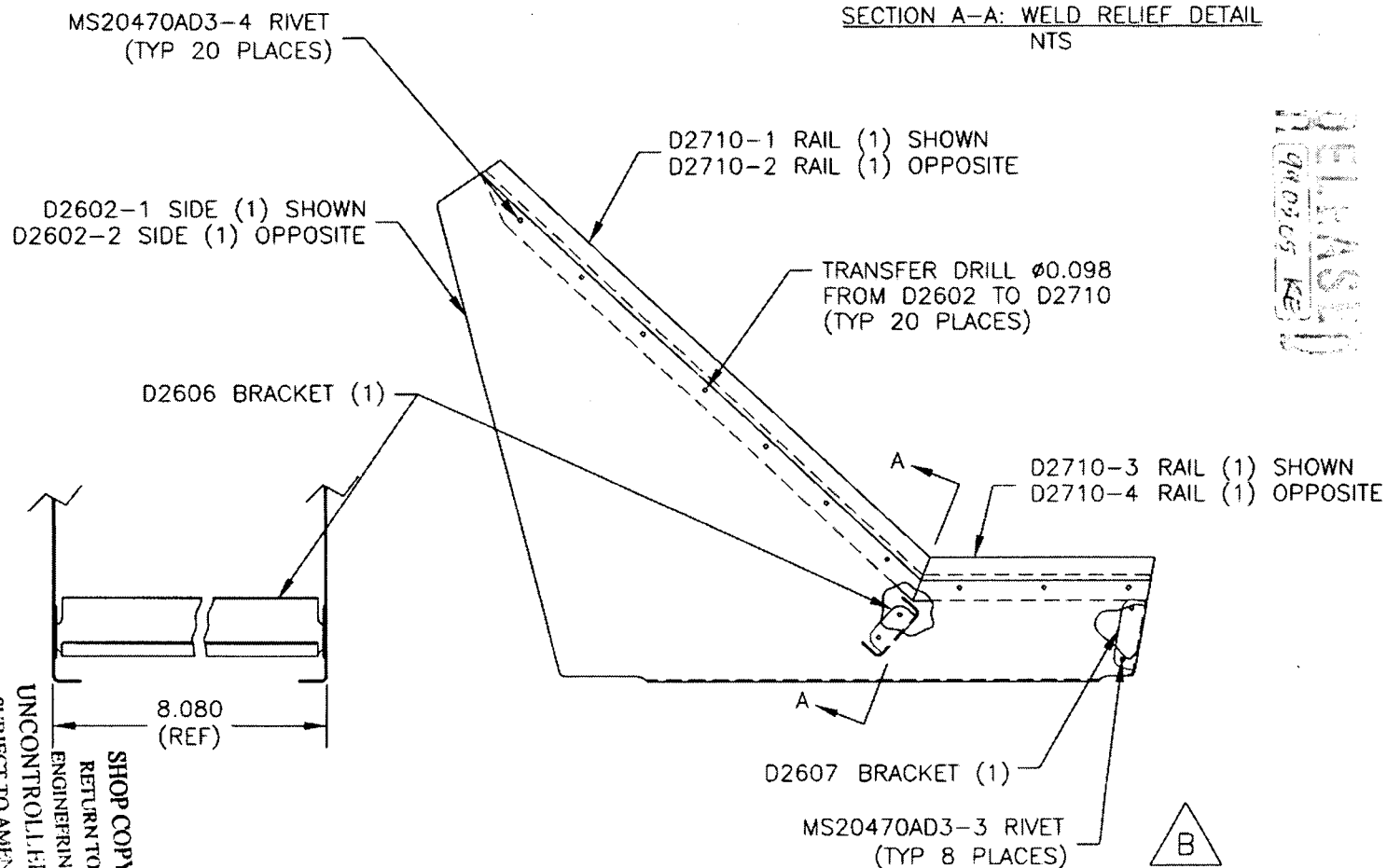
DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWESBURY, ONTARIO, CANADA
CHECKED JP	APPROVED KE	DRAWING NO. D206-547
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	REV. F SHEET 2 OF 5
		SCALE 1:4



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS

RELEASED
11 040305 KE



D206-547-043 (206 HIGH SLOPE CONSOLE)

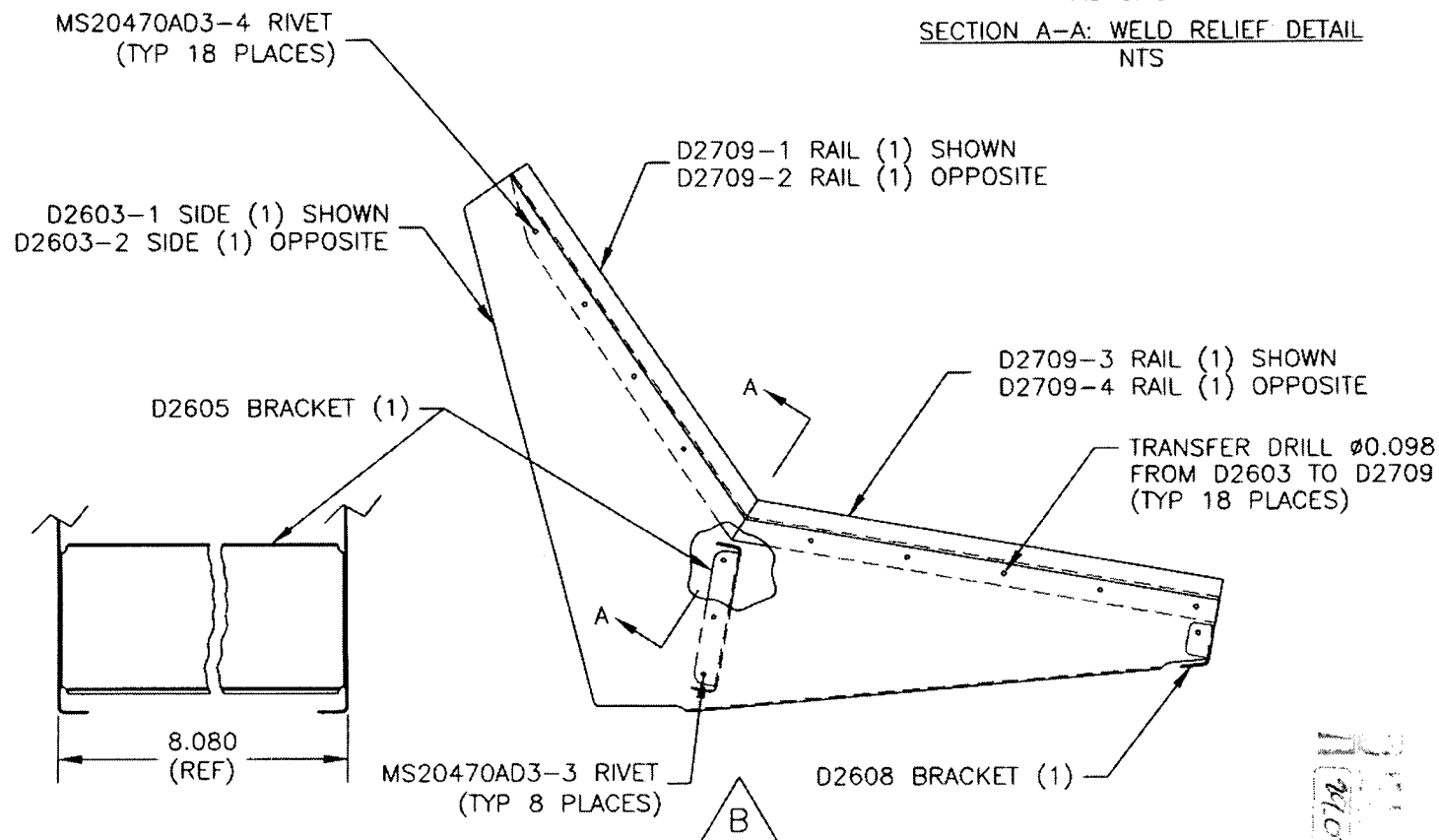
FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	BW	DRAWN BY	RF	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	UP	APPROVED	KE	
DATE	99.02.11	DRAWING NO.	D206-547	REV. F
		TITLE	CONSOLE ASSEMBLY	SHEET 3 OF 5
				SCALE 1:4



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D407-547-045 (407 LOW SLOPE CONSOLE)

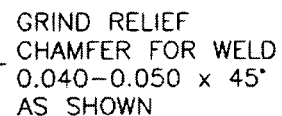
FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN B.W.	DRAWN BY P.F.	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED J.P.	APPROVED K.E.	DRAWING NO. D206-547	REV. F
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	SHEET 4 OF 5	SCALE 1:4

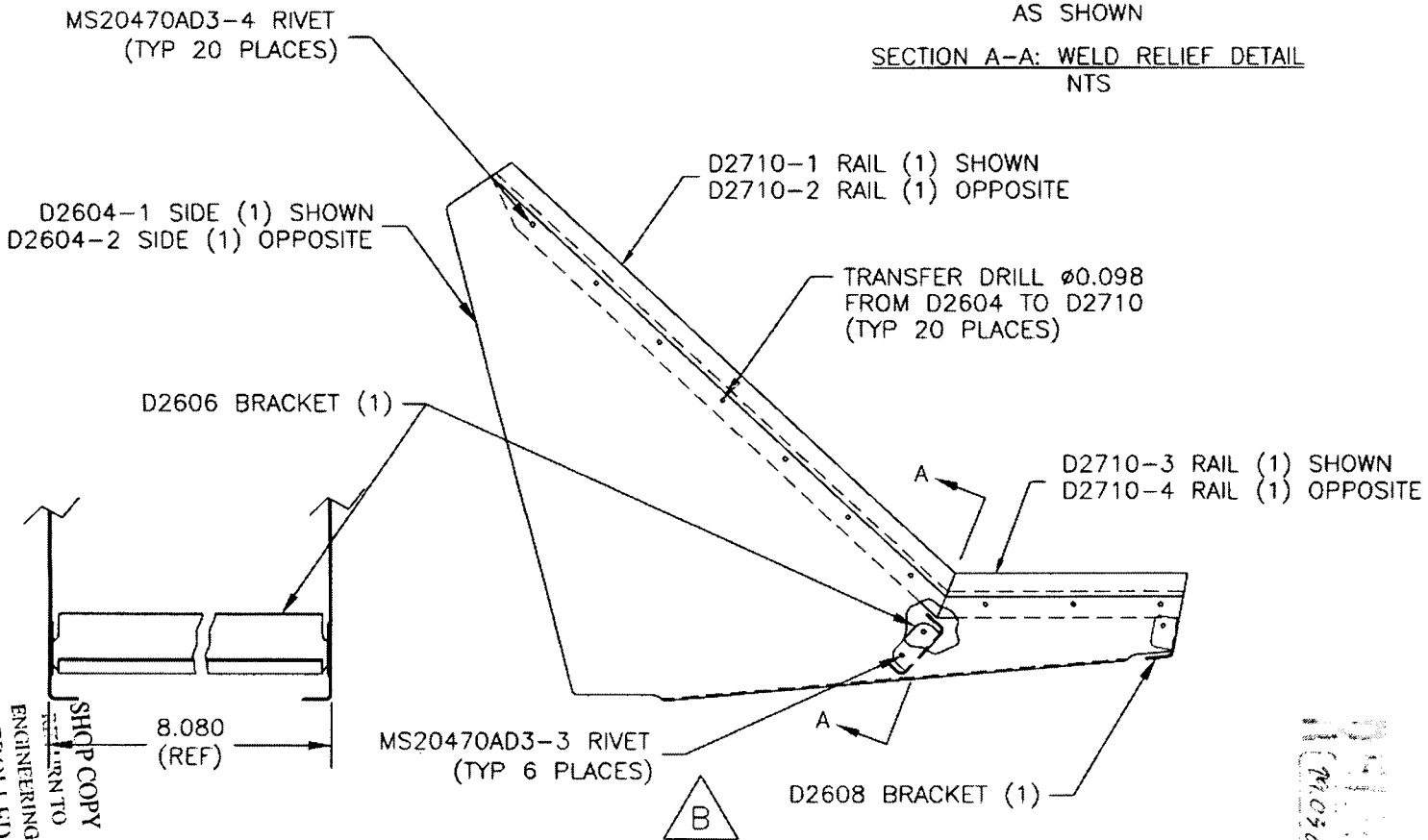
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DART



SECTION A-A: WELD RELIEF DETAIL
NTS



D407-547-047 (407 HIGH SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
Bw	KF	DRAWING NO.	REV. F
CHECKED	APPROVED	D206-547	SHEET 5 OF 5
UP	KE	TITLE	SCALE
DATE		99.02.11	1:4
CONSOLE ASSEMBLY			

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